

March-18-15 9:56:49 AM

130632

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Mounting Lug

Start Date: 3/18/15 **Start Qty:** 30.00

30

Cust Item ID:

Required Date: 5/01/15 **Req'd Qty:** 30.00

30

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2616	Rev E

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.000" long +0.030" -0.000"

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D2616-1 & DWG D2616 2-Tumble & Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

OC

Memo

0.00

Quality Control

Work Order ID 130632

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Page 2

Item ID: D2616-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 3/18/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 5/01/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						30			2153-30
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									15-4-7 DGL
HandFinish	Memo	0.00							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150						30			15-4-14 34 38
Powdercoat	Memo	0.00							
Powder Coating	Note:Mask large hole								
	TEMPERATURE: 320.5 FINISH TIME: 8:05								

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130632

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

**DAS
30
9-89**

APR 15 2015

170

0.00

1-Coat bearing in light oil 2-Press Bearing in D2616-13-Stake as per Dwg D2616 using DT8019 4- Touch up paint if required

30 FF APR 15 2015

0.00

180

0.00

Quality Control

30 _____ DAS
38
9-02
APR 15 2015

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Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Mounting Lug

Start Date: 3/18/15 **Start Qty:** 30.00

30

Cust Item ID:

Required Date: 5/01/15 **Req'd Qty:** 30.00

30

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

190

Identify as per dwg & Stock Location: 51259 0.00

0.00

190

Packaging

Memo

0.00

Packaging

DAS
27
9-29

APR 15 2015

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 15-04-16

mf 15-4-16

Picklist Print

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Page 1

Work Order ID: 130632

130632

Parent Item: D2616-1

D2616-1

Parent Item Name: Mounting Lug

Start Date: 3/18/15

Required Date: 5/01/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:C00.06.22Removed P/O for powder coatEC
IPP Rev:D 07-12-17 rev E as per dwg ECN 1069 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			100	Each	98.0000	1	30			

D2611

Bearing

**

30 FF

15/03/26

Location

Loc Qty

Loc Code

ST008A 131130

58

124478

8

128963

50

ST012a

20

130047

20

ST12a

20

127926

20

M6061T6B1.000X02.00
0

Purchased

No

170

f

28.0000

0.1666

6

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

**

Location

Loc Qty

Loc Code

MAT

24

M131653

24

MAT003

4

M131392

4

15/03/26

5,2'

DART AEROSPACE LTD		Work Order: 130632
Description: Fwd Mounting Lug		Part Number: D2616-1
Inspection Dwg: D2616	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

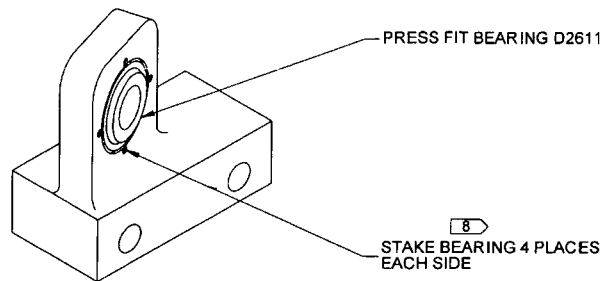
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17°	+/-0.5°	17°	✓		—	SQUARES
2.000	+/-0.010	2.000	✓		MIP-04	vern
0.622	+/-0.010	0.622	✓		...	...
0.511	+/-0.010	0.511	✓		↓	↓
0.313	+/-0.010	0.310	✓			
1.000	+/-0.010	0.995	✓			
1.125	+/-0.010	1.123	✓			
0.250	+/-0.010	0.246	✓			
1.250	+/-0.010	1.250	✓			
0.375	+/-0.010	0.370	✓			
0.625	+/-0.010	0.627	✓			
1.259	+/-0.010	1.259	✓			
0.625	+/-0.010	0.624	✓			
R0.250	+/-0.010	0.250	✓			
R0.063	+/-0.010	0.063	✓			
Ø0.257	+0.006/-0.001	0.258	✓			
Ø0.8115- Ø0.8120	N/A	0.8115	✓			

Measured by: <i>HJP</i>
Date: 15/03/27

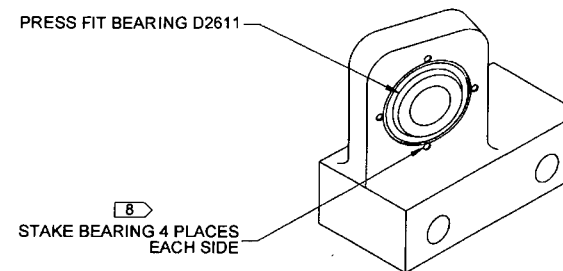
Audited by: <i>Jh</i>
Date: 15-3-30

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	<i>[Signature]</i>



D2616-1 FWD MOUNT LUG



D2616-2 FWD MOUNT LUG

alb 130632

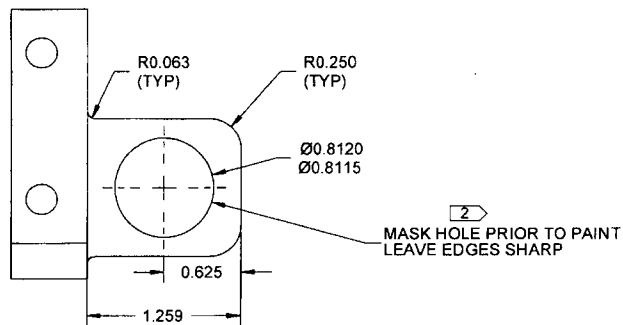
QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

NOTES:

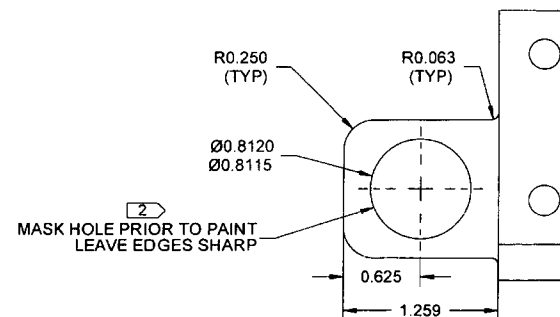
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

RELEASED
07.12.12

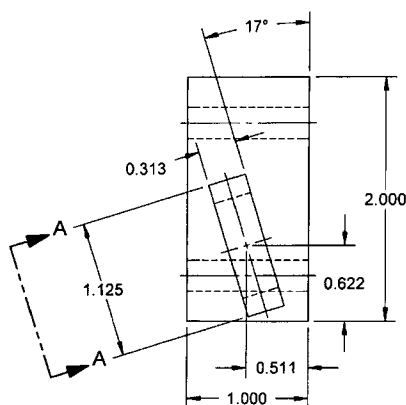
E	UPDATE DWG: SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	97.07.31
C	REMOVE D2616-3	BW	97.06.04
B	RE-DESIGN	KE	97.05.06
A	ORIGINAL ISSUE	BW	96.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2616	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



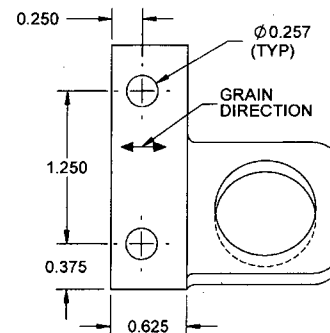
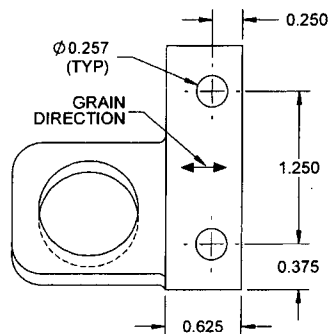
VIEW A-A



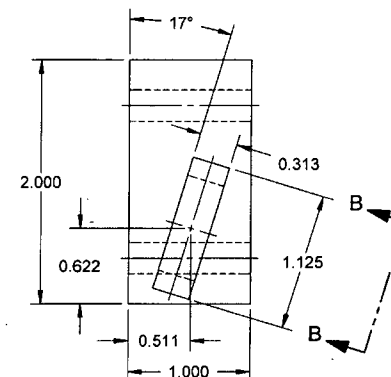
VIEW B-B



D2616-1A LUG



D2616-2A LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07.12.12

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	LC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	MS	D2616	SHEET 2 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	